

Work Order ID 79054

79054

Page 1

January-19-12 9:29:19 AM

Item ID: D4149-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Aft

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4149

C

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location 468

0.00

120

Packaging

Memo

0.00

Packaging

Handwritten signature and date 12/02/01 with circled 4

Circled handwritten number 4

Handwritten date 12/12/12 and signature

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79054***79054***

Page 2

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NS1

Revision ID:

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NS2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/2/2 20
P12-02-2
(4)

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Picklist Print

January-19-12 9:29:24 AM

Page 1

Work Order ID: 79054

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21043-3

Purchased

No

100

Each

1,243.000

4

8

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

632

119901

632

ST301

539

118077

2

118614

441

118686

30

119758

66

MS21043-4

Purchased

No

100

Each

1,035.000

1

12

MS21043-4

Nut

**

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

525

119309

29

119546

496

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Page 2

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3910-1 Manufactured No

100 Each 26.0000 i 4

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

st507

26

78326

26

D4091-1 Manufactured No

100 Each 11.0000 i 4

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST458

11

77320

11

D4149-1 Manufactured No

100 Each 21.0000 2 8

D4149-1

Crosstube Lug Plate, Aft

**

Location

Loc Qty

Loc Code

ST133

21

78044

21

D4149-3 Manufactured No

100 Each 36.0000 1 4

D4149-3

Spacer

**

Location

Loc Qty

Loc Code

ST133

36

78046

36

D4149-5 Manufactured No

100 Each 4.0000 1 4

D4149-5

Eyebolt Stud

**

Location

Loc Qty

Loc Code

ST133

4

73548

4

January-19-12 9:29:24 AM

Shop Packet Print

Page 2

B79057 (3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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January-19-12 9:29:24 AM

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C12A Purchased No

100 Each 40.0000 2 8

AN3C12A

Bolts

**

Location

Loc Qty

Loc Code

ST351

40

117514

4

118112

5

118422

8

118451

22

119510

1

AN4C13A Purchased No

100 Each 39.0000 3 12

AN4C13A

BOLT

**

Location

Loc Qty

Loc Code

ST357

39

120187

39

MS20615-4M18 Purchased No

100 Each 407.0000 3 12

MS20615-4M18

Rivet

**

Location

Loc Qty

Loc Code

ST323

407

118077

243

118543

164

NAS1149C0332R Purchased No

100 Each 2,736.000 4 16

NAS1149C0332R

Washer

**

Location

Loc Qty

Loc Code

ST297

2736

118354

705

119736

2031

January-19-12 9:29:24 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

3,452.000

6

24

NAS1149C0432R

**

Washer

Location

Loc Qty

Loc Code

ST297

3452

117291

2452

119124

1000

EP 12/02/01
24

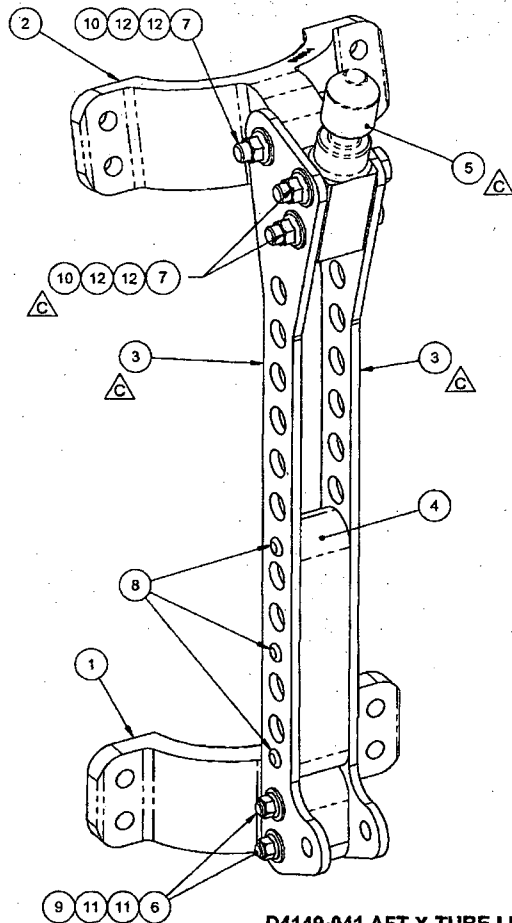
W/O:		WORK ORDER CHANGES					
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D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20815-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

UNCLASSIFIED
SUBMITTAL

NO 79054 MLO
12/01/19

RELEASED
2011-02-24
JW

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C9-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20815-4M18 WAS MS20815-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(5) MS20815-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4149

TITLE
AFT X-TUBE LUG ASSY

REV. C
SHEET 1 OF 5
SCALE
NTS

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Dart Aerospace Ltd

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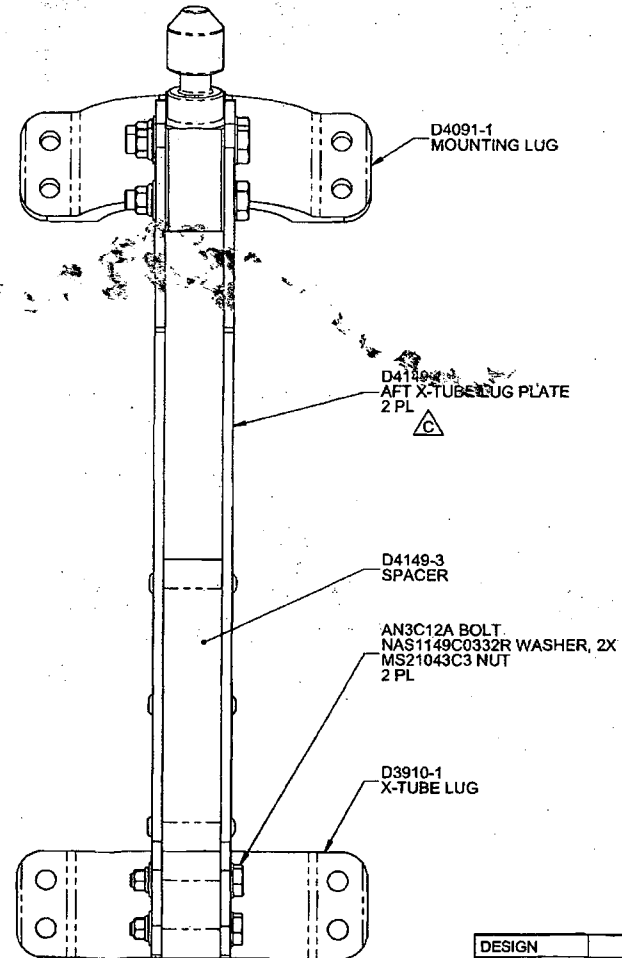
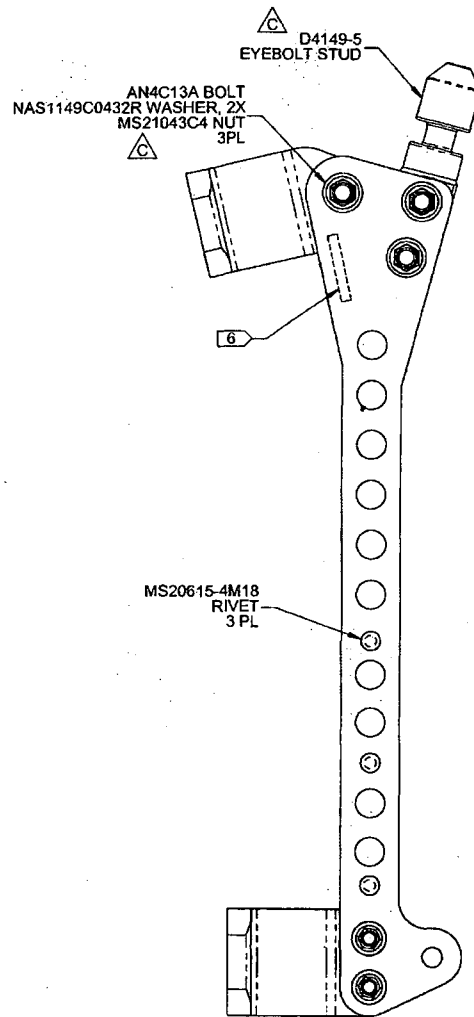
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79054



D4149-041 AFT X-TUBE LUG ASSY

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2011-02-24
MP

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

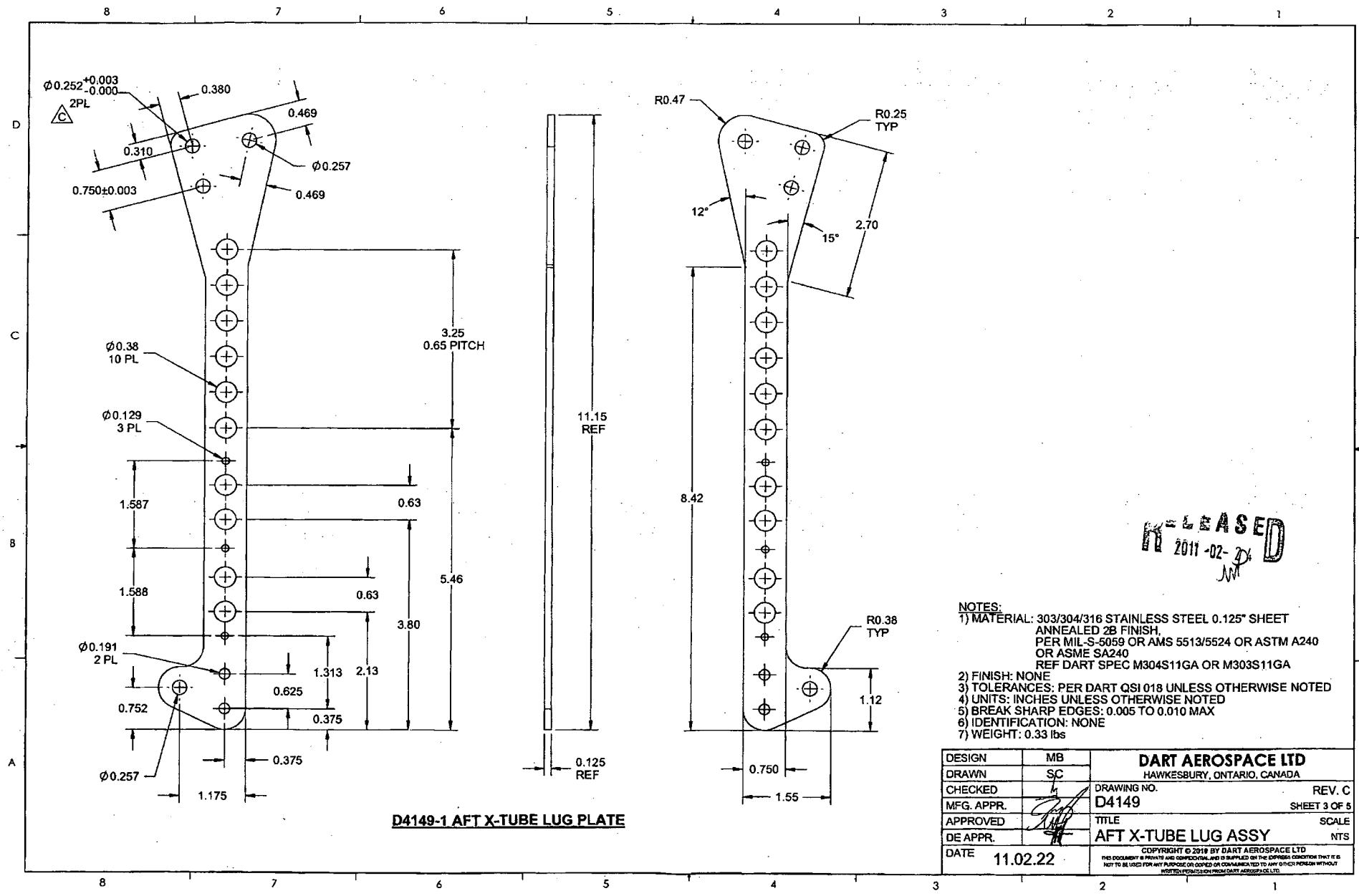
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries

79054



RELEASED
2011-02-24

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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W/O:		WORK ORDER CHANGES					
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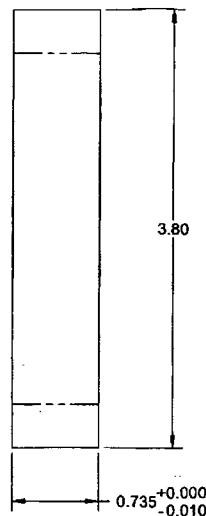
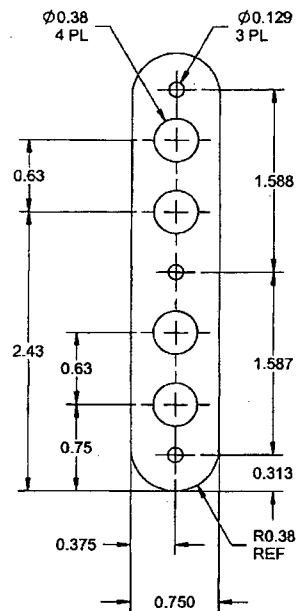
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

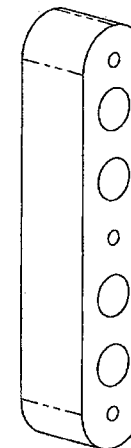
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79054





D4149-3 SPACER



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

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2011-02-22

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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
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DE APPR.		AFT X-TUBE LUG ASSY	NTS
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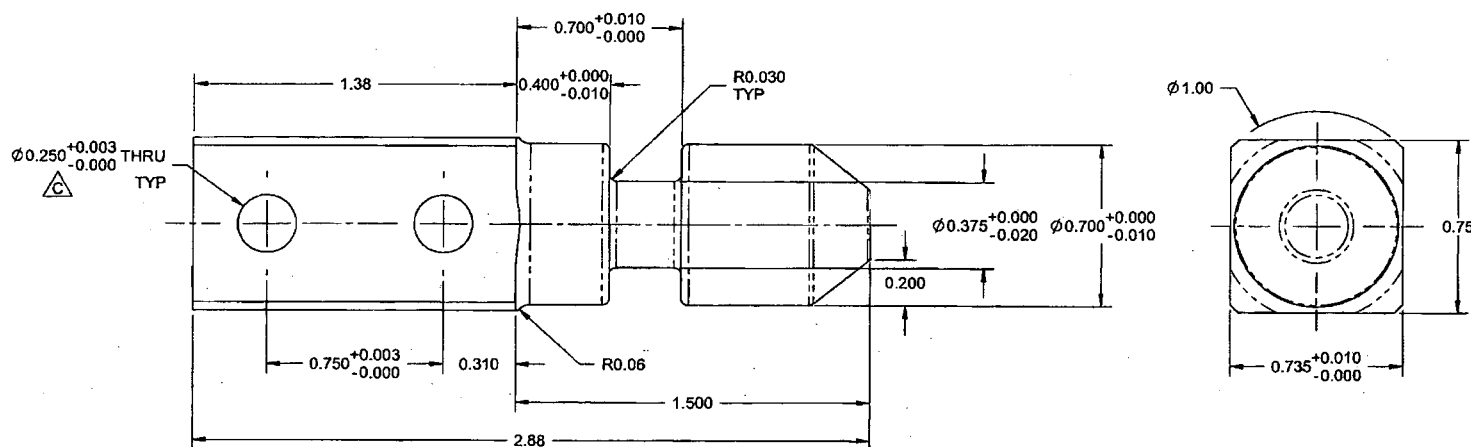
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79054



D4149-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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